

# Work Order ID 50381



Page 1

July 13, 2009 12:34:57 PM

Item ID: D3817-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Anchor Nut Plate

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-07-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3817

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3817-1

☐ Dwg Rev: A

☐ Prog Rev: A

☐ 2-

Deburr if necessary

HB 9-8-4

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 9-8-4

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

2> 502108104

count  
(420)

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SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- countersink holes at 6 places as per dwg D3817-02- deburr if necessary

*Ep09/08/06* (20)

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*=> S 08/02/06*

*center*  
(420) *✓*

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*HR 09-08-7*

(20)

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Item Name: Anchor Nut Plate

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09-08-04 (X20) JH

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- install anchor nuts and rivets as per dwg D3817

EP 09/08/13 (20)

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=&gt; 8/5/09/13

counter (20) P

# Work Order ID 50381

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Item ID: D3817-041

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Setup Start



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Stop



Item Name: Anchor Nut Plate

Start Date: 7/15/09 Start Qty: 4.00



Cust Item ID:

Required Date: 7/15/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 09-07-15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>134</u>	0.00							
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

(120)

MD 08/08/17

09/08/25

MF 09-08-24

7681

## Picklist Print

July 13, 2009 12:34:57 PM

Page 1

Work Order ID: 50381

Parent Item: D3817-041RevA

Parent Item Name: Anchor Nut Plate


Comments:

Start Date: 7/15/09

Required Date: 7/15/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			170	sf	135.5726	0.0493	20		
												
6061-T6 .063 Sheet												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

MAT

135.5726316

109463

1

110551

134.572632

MS20426AD3-4

Purchased

No

110

Each

8,433.000

24.0000

RIVET

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

8433

104374

4433

110398

4000

MS21059L3

Purchased

No

170

Each

871.0000

12.0000

Nut Plate

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

871

109962

371

111925

500

110 SST 1B 9-8-4 20

EP 09/08/13

EP 09/08/13

60

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	50381
<b>Description:</b> Plate		<b>Part Number:</b>	D-3817-41
<b>Inspection Dwg:</b> D3817-1	<b>Rev:</b> A	<b>Page 1 of 1</b>	

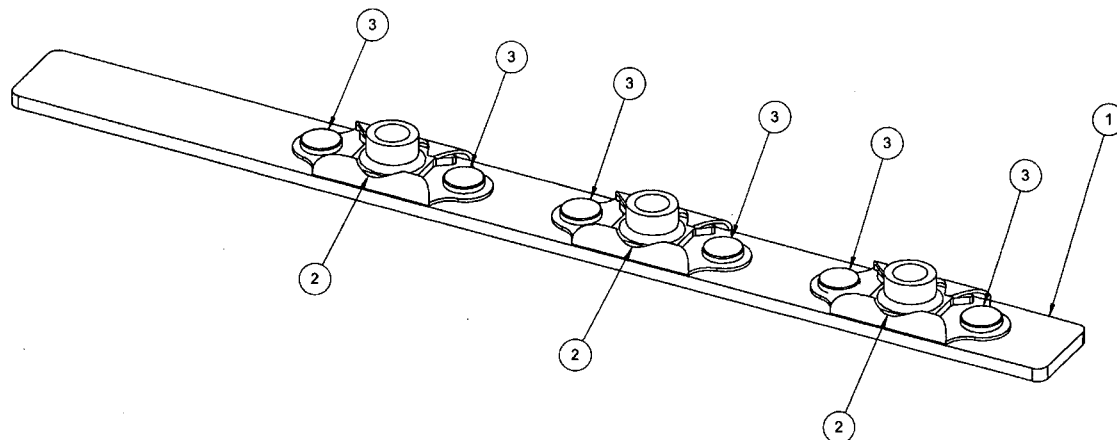
## FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**      ☐ **Prototype**

[illegible]

Measured by:	IB	Audited by:	S	Prototype Approval:	
Date:	9-8-4	Date:	05/05/04	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



ITEM NO.	PartNo	DESCRIPTION	QTY.
1	D3817-1	PLATE	1
2	MS21059L3	ANCHOR NUT	3
3	MS20426AD3-13	RIVET	6

**D3817-041 ANCHOR NUT PLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50331

MF 09-07-15

RELEASE  
09/01/13 MFL

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3817-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.02 lbs

A	NEW ISSUE		08.09.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.11		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3817</b>	REV. A SHEET 1 OF 2
TITLE <b>PLATE</b>	SCALE NTS
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8 7 6 5 4 3 2 1

D

D

C

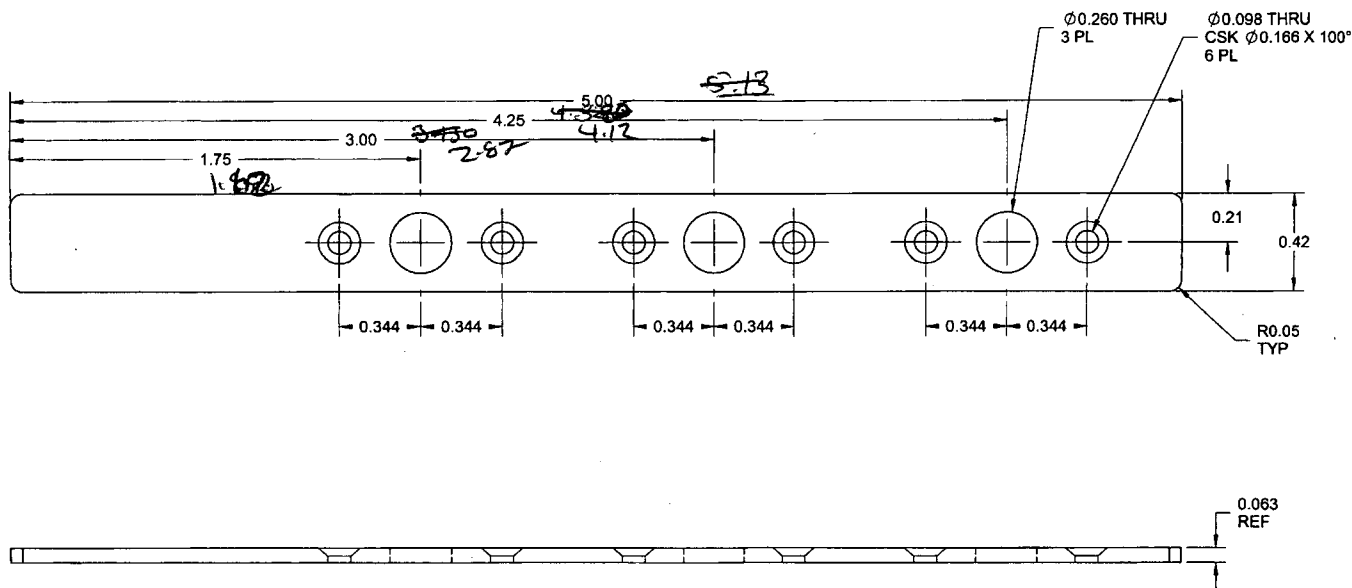
C

B

B

A

A



**D3817-1 PLATE**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 50381  
MF 09-07-15

**RELEASED**  
09/01/12

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3817	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLATE	NTS
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8 7 6 5 4 3 2 1